Qty:

User.

Wednesday, 30/07/2008 12:54:54 PM

Jean-Luc Menard

Process Sheet

Drawing Name

Part Number

Drawing Number

Customer Job Number : CU-DAR001 Dart Helicopters Services

S.O. No. :

: 40830

: 11010

Estimate Number P.O. Number

This Issue : 30/07/2008

: NC Prsht Rev.

First Issue : // : 39883

Previous Run Written By

Checked & Approved By

Comment

MACHINED PARTS

Project Number Drawing Revision Material

Due Date

6061-T6 RD Tube .375 x.058W

HARDINGE CNC LATHE SMALL

: 06/08/2008

: D2649

N/A

B1

D2649 REV B1

: CROSSBOLT SPACER

100 Um:

Each

Additional Product

Job Number:



: Est F 02.03.26

Seq. #:

Machine Or Operation:

Description:

Added turning on Cobra NG

1.0

M6061T6T0375W058

Comment: Qty.: 0.2975 f(s)/Unit Total: 6061-T6 Tube .375 x.058W

Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall

HARDINGE 2.0

Comment: HARDINGE CNC LATHE SMALL Machine as per folio

on cobra machine.

29.7465 f(s)

INSPECT PARTS AS THEY COME OFF MACHINE





QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

3.0



Comment: SECOND CHECK

PACKAGING 1 5.0

PACKAGING RESOURCE #1

SECOND CHECK



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

NCLAY

FINAL INSPECTION WIP RELEASE

6.0

QC21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





DART AEROSPACE LTD	Work Order:	40830
Description: Crossbolt Spacer	Part Number:	D2649
Inspection Dwg: D2649 Rev: B1	(1)	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.180	+0.030/-0.000	3.184"				
0.375	+/-0.010	0,375		_		
0.025 - 0.030	N/A	3,184" Ø, 375" ,025"				
						AND U.S. STATES AND ST
				,		

Measured by: J.F.	Audited by:	Prototype Approval:	N/A
Date: 08/08/01	Date: 08 08 6)	Date:	N/A

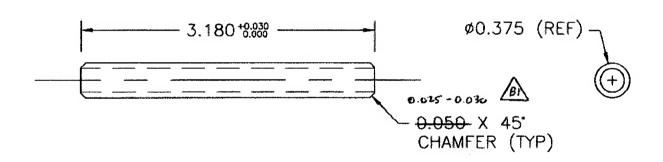
Rev	Date	Change	Revised by		Approved
Α	04.01.21	New Issue	KJ/RF	1	7
				I^{-}	



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	DESIGN DRAWN BY			DART AEROSPACE USA, INC.				
ı	CHEC	KED_	APPROVED	DRAWING NO. REV. B				
		JUS -	BW	D2649 SHEET 1 OF 1				
1	DATE			TITLE SCALE				
	98.0	01.14		CROSS BOLT SPACER 1:1				
	Α		97.03.25	NEW ISSUE				
- Charles Control	В		98.01.14	3.180 WAS 3.230, ADD CHAMFER				
	Bı	# (P	02.06.13	REDUCE CHAMPER PER TSR 1206.				

RELEASED PS

w/ 40/30



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4) 0.375 DIA 0.058 WALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED